

# Work Order ID 72640

Wednesday, August 03, 2011 1:38:51 PM

Page 1

**PRELIMINARY ISSUE**

Item ID: D4406-043

Accept

Revision ID: PRELIM

Item Name: Aft Wearplate Assembly

Start Date: 8/3/2011 Start Qty: 1.00

Required Date: 8/5/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4406

100

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per dwg D4406

prog rev: PAS  
dwg rev: PAS

2-Deburr if required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B11-8-3

①

B11-8-3

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**Accept**

**Setup Start**

**Stop**

**Cust Item ID:**

**Customer:**

**Reference:**

Run Start

Date:

Date:

**Stop**

**Insp.**  
**Stamp**

0.00 - inspected by PFS

0.00 Dry aly

0.00

0.00

0.00

Form as per dwg D4406

0.00

0.00

## Quality Control

test fit before welding - Don Staw

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Item ID: D4406-043

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Aft Wearplate Assembly

Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 		0.00							
Large Fab						x/		11-8-8	JBL
Large Fab	Memo weld wearplate as per dwg D4406 M118196 M117859	0.00							
160 	QC10- Inspect visual per QS1004- ground welds	0.00							
QC	↑ QCS	0.00							
Quality Control	Memo								
170 		0.00							
Small Fab									
Small Fab	Memo Apply coating as per dwg D4406 M118000	0.00							

- inspector to PAS  
Dug only  
Smo2/08 @

11/08/11

POSITIVE RECALL

EFFECTIVE 11/08/11

AUTH

RELEASED 11/08/11

DATE

11/08/26

**Work Order ID 72640**

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Item ID: D4406-043

Accept

Revision ID: PRELIM

Item Name: Aft Wearplate Assembly

Start Date: 8/3/2011 Start Qty: 1.00

Required Date: 8/5/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00 - inspect to P25

QC

Memo

0.00 Drawnically

Quality Control

8/3/2011

190

Identify as per dwg &amp; Stock Location: ST

0.00

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

U 110829

# Picklist Print

Page 1

Wednesday, August 03, 2011 1:38:48 PM

Work Order ID: 72640

Parent Item: D4406-043

Parent Item Name: Aft Wearplate Assembly



Start Date: 8/3/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 11.06.06new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4407-3 		Manufactured	No			150	Each	0.0000	1	1			
Bar													
M304S18GA 		Purchased	No			100	sf	237.6550	3.21	3.378947			
304/316 .050 Sheet													

B72641 1108.05

B10-8-3

Location	Loc Qty	Loc Code
MAT020	85.655	
113062	13.655	
116135	3	
116979	69	
MAT021	152	
118217	152	

116135

1

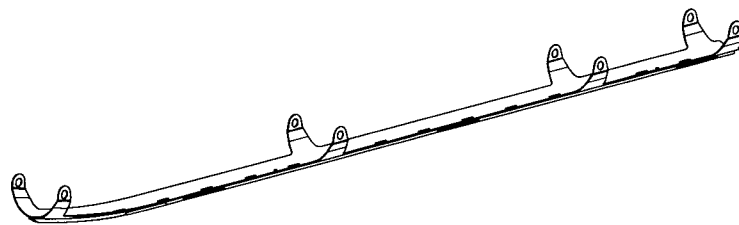
DART AEROSPACE LTD		Work Order: 72640
Description: AFT WEAR PLATE ASSEMBLY		Part Number: D4406-043
Inspection Dwg: D4406-3, Rev: PAK		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

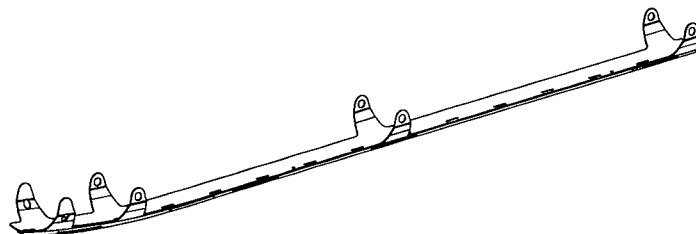
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ .188	+.005 - .001	.189	✓		V RBZ	
.561	±.010	.562	✓		V	
.88	±.030	.88	✓		V	
.13	±.030	.129	✓		V	
1.76	±.030	1.776	✓		V	
7.77	±.030	7.770	✓		V	
7.203	±.010	7.204	✓		V	
3.63	±.030	3.626	✓		V	
7.00	±.030	7.003	✓		V	
27.50	±.030	27.50	✓		T RBZ	
58.12	±.030	58.12	✓		T	
7.133	±.010	7.130	✓		V	
7.78	±.030	7.777	✓		V	
2.43	±.030	2.432	✓		V	
7.567	±.010	7.563	✓		V	
8.17	±.030	8.164	✓		V	
24.995	±.010	25.00	✓		T	
47.833	±.000	47.833	✓		T	
54.053	±.010	54.053	✓		T	
.052	±.010	.047	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:		
Date: 11-6-3	Date: 11/6/03	Date:		
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D4406-041 FWD WEARPLATE ASSY**



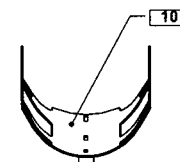
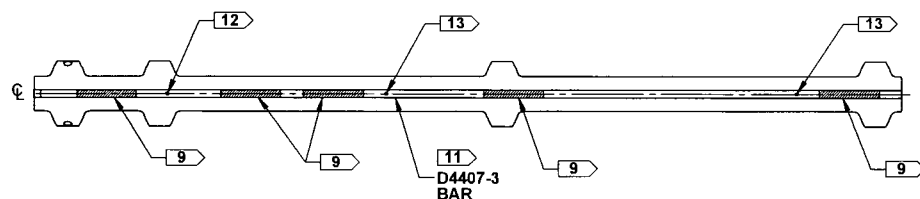
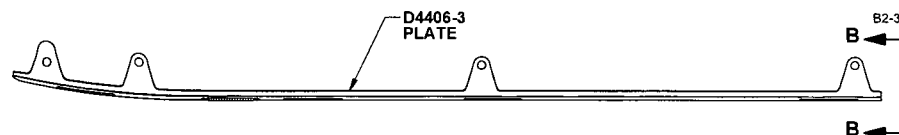
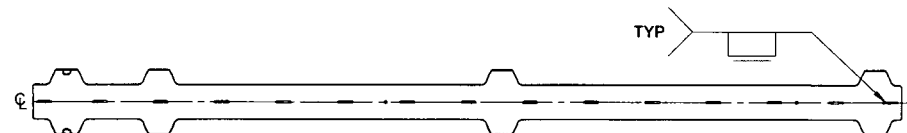
**D4406-043 AFT WEARPLATE ASSY**

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	1		D4407-1	BAR
6		1	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2 & 3)

## PRELIMINARY ISSUE

~~11~~ 11.07.28

PAS	47.833 WAS 47.883 & 54.053 WAS 53.973 (ZN C5-5); 7.77 WAS 7.78 & 7.203 WAS 7.214 (B7-5)	RF	11.07.28
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA5
MFG. APPR.		D4406	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.07.28	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



# **D4406-043 AFT WEARPLATE ASSY**

C3-3 **SECTION B-B**  
SCALE 2X

## **NOTES:**

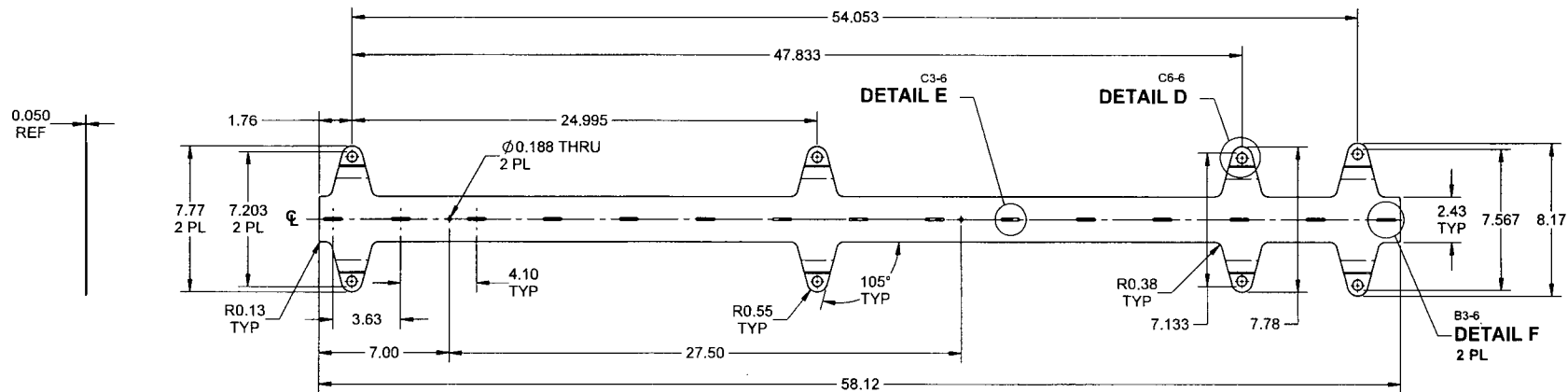
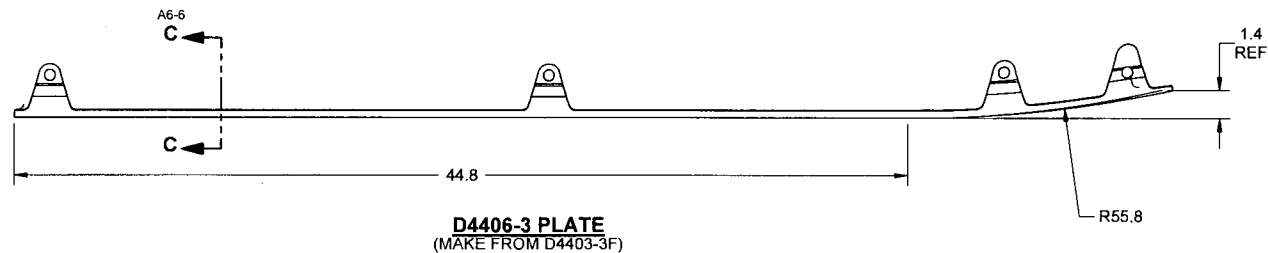
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.57 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON ALL 3 SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER  $\varnothing 0.188$  HOLES FROM D4406-3 TO D4407-3

**PRELIMINARY ISSUE**

11.07.28

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA5
MFG. APPR.		<b>D4406</b>	SHEET 3 OF 6
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**D4406-3F FLAT PATTERN**

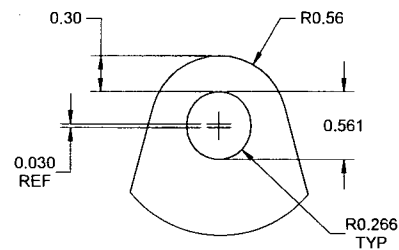
**PRELIMINARY ISSUE**

11.07.28

**NOTES:**

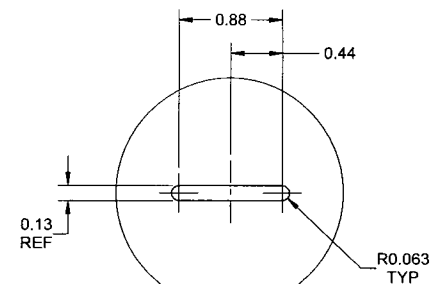
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)  
PER AMS 5513 OR 5524  
OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

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MFG. APPR.		<b>D4406</b>	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>WEARPLATE ASSY</b>	NTS
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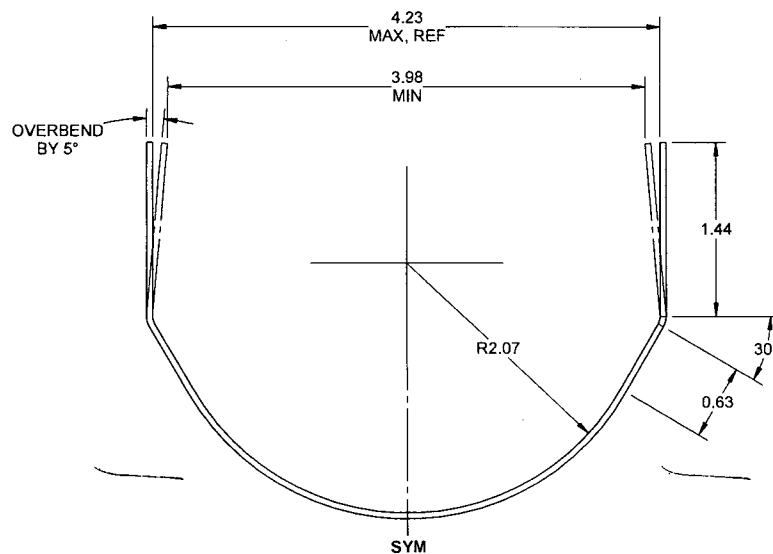
**DETAIL D**  
SLOT DETAIL TYP  
SCALE 6X

C3-4  
C4-5



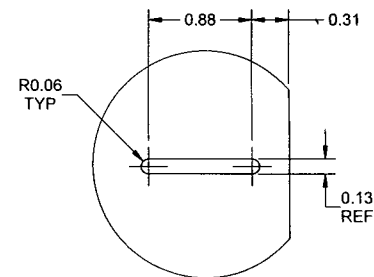
**DETAIL E**  
SLOT DETAIL TYP  
SCALE 6X

C2-4  
C4-5



**DETAIL C**  
DETAIL TYP  
SCALE 6X

D2-4  
D6-5



**DETAIL F**  
SLOT DETAIL TYP  
SCALE 6X

C1-4  
B1-5

**PRELIMINARY ISSUE**

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